

ANODIZE 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4703-043

Job Sheet 201250



Part No: D4703-043

Job Qty: 10 pcs

Part Name: Lock Pin Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/25/19

Description:

Type: SOLD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		10/25/19	0.00	0.67	Bandsaw - 1		OK 19/10/13
110	HAAS 4 Axis - B4B	10 pcs		10/25/19	0.61	5.29	HAAS - 1 - B4B		OK 19/10/13
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs		10/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		OK 19/10/13
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S222161



Part: D4703-043

Job No: 201250

Serial No/Batch: S222161

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/13/19

130 QC 8	10 pcs	10/25/19	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	Done 19-10-15
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
132 Outsource - 4 - Anodize	10 pcs	10/25/19		ATG001-VC	5 Done 2019-10-15
134 Packaging 2-1 - Receive - B4B	10 pcs ✓	10/25/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	✓ Done 2019-10-15
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP NOV 05 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	

				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
136 QC 6	10 pcs	10/25/19	0.00 0.00	QC 6 - 9	DAS 81 9-89 NOV 19 2019
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
137 Small Fab - 2 - B4B	10 pcs	10/25/19	0.00 0.83	Small Fab - 1 - B4B	DAS 58 9-89 NOV 22 2019
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
138 QC 5	10 pcs	10/25/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				Plex 10/3/19 11:09 AM dart.lacelle.linda	

						QC 5 - 51			
						QC 5 - 58			
						QC 5 - 68			
						QC 5 - 9			
						QC 5 - 50			
						QC 5 - 30			
						QC 5 - 40		NOV 2 5 2019	
						QC 5 - 61			
						QC 5 - 81			
140	Packaging 3-1 - Stock - B4B	10	✓	10/25/19	0.00	0.00	Packaging 3 - 1 - B4B		
	pcs						Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B	✓	ST110 Oscar
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		
							Packaging 3 - 17 - B4B		
							Packaging 3 - 18 - B4B		
							Packaging 3 - 19 - B4B		
							Packaging 3 - 20 - B4B		
							Packaging 3 - 21 - B4B		
							Packaging 3 - 22 - B4B		
							Packaging 3 - 23 - B4B		
							Packaging 3 - 24 - B4B		
							Packaging 3 - 25 - B4B		
							Packaging 3 - 26 - B4B		
							Packaging 3 - 27 - B4B		
							Packaging 3 - 28 - B4B		
							Packaging 3 - 29 - B4B		
							Packaging 3 - 30 - B4B		
							Packaging 3 - 31 - B4B		
							Packaging 3 - 32 -		

				B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	10 ☒ pcs	10/25/19	0.00 0.00	QC 21 - SA - 21 ☒	ST 110
				QC 21 - SA - 70	DAS 21
				QC 21 - SA - 53	NOV 26 2019

Part Op 100 - (Bandsaw) -Cut blanks to 2.6"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine as per DWG D4703-1 and folio FB519 FOLIO REV: AA DWG

REV: B 2-Deburr

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

132 - Issue P/O to ATG: 44771 -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -As Per Dwg D4703 -Material type; 6061T6 -Certificate of Conformity is required

134 - (Receive & Inspect for Damage & Mat'l Certs)

136 - (QC6- All purchased or subcontracted products)

137 - (Small Fab) Assemble as per DWG sheet 2 *Install ~~the~~ helicoil using 1/4-28 handle.*

138 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

DAS 81 9-89
DAS 35 9-89

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.000	6061-T6 Bar .750 X 1.00	2.2000 ft (.22 ea)	100-Bandsaw - 1	S168971
MS21209-F415	Heli-Coil	10 Ea (1 ea)	137-Small Fab - 2 - B4B	

ST296

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X01.000	2	5	0
137-Small Fab - 2 - B4B	MS21209-F415	10	36	0

Part Specifications	
Specifications could not be found.	

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S168971

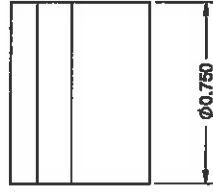
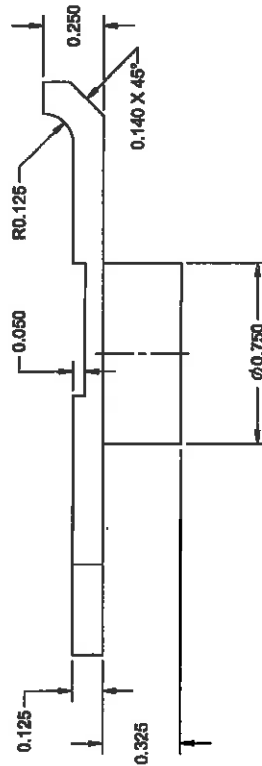
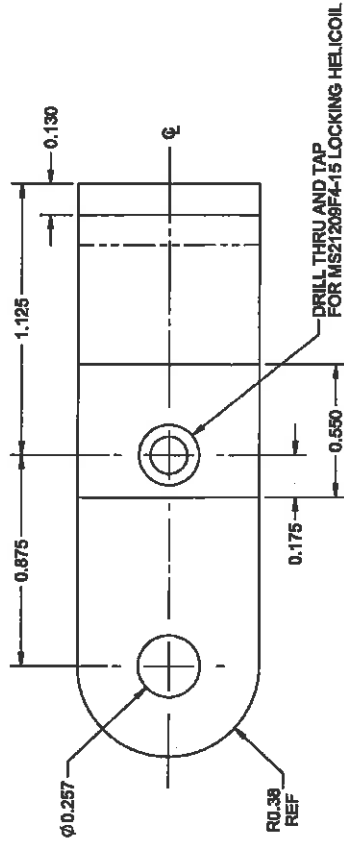
Start = 60.75 po.

End = 34.125 po

Used = 26.625 po / 2.219 ft.

BOM 2.200 ft.

Scrap = 0.019 ft.



D4703-1 LOCK PIN BASE

UNDER REVIEW
URF 19-914/19.09.19 SAD

- NOTES:**
- 1) MATERIAL: 6061-T6/7051 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M5061T6B
 - 2) FINISH: BLACK ANODIZE PER MIL-8628F, TYPE III, CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.04 lbs

RELEASED
2017 MAY 24

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.
DRAWN	VS	EUGENE, OR
CHECKED	WK	DRAWING NO.
MFG. APPR.	JLM	D4703
APPROVED	HS	REV. B
DE APPR.	DS	SHEET 4 OF 5
DATE	17.01.03	TITLE
		LOCK PIN ASSY
		SCALE
		NTS

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UNLESS INDICATED OTHERWISE

201212150450-01

OK For
-473
19/10/13



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS						MRB (QSI042)			
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____		Sequence #: _____		QTY Affected: _____									
Description Work Order Deviation				Disposition									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY									
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
				Completed By		Lead hand / Supervisor		QC / QA Coordinator					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044771



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044771

PO Date: 10/15/19

Due Date: 10/29/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200356	646/2910	646.2900 Rev N/C	Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	-	10/29/19	12 pcs	0 pcs	12 pcs	\$48.74/pcs	\$584.88
2	201250	D4703-043	D4703 Rev B	Lock Pin Base : Various STC's Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -As Per Dwg D4703 -Material type: 6061T6 -Certificate of Conformity is required	Firmed	-	10/29/19	10 pcs	0 pcs	10 pcs	\$3.44/pcs	\$34.40

X10

NOV 05 2019

OP



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044771



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	198841	D4842-4	D4842 Rev B	Lower Cutter Body, RH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A- 8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P- 23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005, C OF C IS REQUIRED	Firmed	-	10/29/19	16 pcs	0 pcs	16 pcs	\$10.99/pcs	\$175.84
4	198840	D4842-3	D4842 RevB	Lower Cutter Body, LH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A- 8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P- 23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005, C OF C IS REQUIRED	Firmed	-	10/29/19	16 pcs	0 pcs	16 pcs	\$10.99/pcs	\$175.84
5	200585	646.3210	646.3200 Rev NC	Support : Various STC's Issue P/O to ATG : 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	-	10/29/19	20 pcs	0 pcs	20 pcs	\$15.09/pcs	\$301.80
6	197033	649.4813	649.4800 Rev E	Shim : Various STC's Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1)ISSUE P/O: As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A- 8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P- 23377J Type1 Class N	Firmed	-	10/29/19	26 pcs	0 pcs	26 pcs	\$6.99/pcs	\$181.74
7	200990	646.3712	646.3700 Rev A	Clip : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg 646.3712 Rev. A	Firmed	-	10/29/19	25 pcs	0 pcs	25 pcs	\$6.84/pcs	\$171.00



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PURCHASE ORDER

POHB044771



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	200588	646.3711	646.3700 Rev A	Clip : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3700 Rev. A	Firmed	-	10/29/19	24 pcs	0 pcs	24 pcs	\$6.84/pcs	\$164.16
9	200365	646.3312	646.3300 Rev A	Center Plate : Various STC's Issue P/O to ATG : Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C	Firmed	-	10/29/19	20 pcs	0 pcs	20 pcs	\$12.79/pcs	\$255.80
Grand Total:											\$2,045.46	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/28/19 8:35 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918832

Date: 25-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: D4703-043 Lock Pin Base Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime IAW MIL-P-23377J, Type I, Class N Batch/Lot#: _____ Job: 26314 PO: POHB044771	Rev: B	DAS 81 3-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>OCT 25 2019</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			

RECEIVED
NOV 04 2019
DART AEROSPACE LTD.